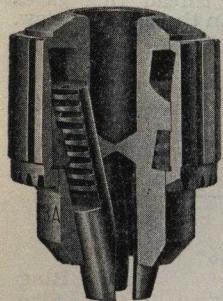


# JACOBS CHUCKS

Variety of models meets all light and heavy duty requirements. Unanimous choice of portable tool manufacturers. New easy-grip sleeve, ground inside and out, assures greater accuracy—absolute balance.

## Plain Bearing Improved Chucks



Recommended for use on portable drills, drill presses, bench grinders and tapping devices.

Produced in a variety of models to meet all light and medium duty requirements. Easy-grip sleeve, ground inside and out, results in increased accuracy and absolute balance. Nickel molybdenum alloy steel jaws, heat treated, give a combination of strength and hardness formerly impossible. The hardened and ground body now has a diamond bored taper hole, insuring great accuracy and a perfect fit on the machine spindle.

### LIGHT DUTY—FOR TAPERED ARBORS AND SPINDLES

| Nos.    | Each   | Taper                      |                            | Jaws and   |           | Sleeves, Each |
|---------|--------|----------------------------|----------------------------|------------|-----------|---------------|
|         |        | Cap., In.                  | Hole Nos.                  | Keys, Each | Nuts, Set |               |
| M-0     | \$6.50 | 0- $\frac{5}{32}$          | 0                          | \$0.35     | ± \$2.50  | ± \$1.00      |
| M-1A    | 5.50   | 0- $\frac{1}{4}$           | { $\frac{5}{16} \times 24$ | .35        | ± 2.25    | ± .90         |
| M-2A    | 6.50   | 0- $\frac{3}{8}$           | { $\frac{3}{8} \times 24$  | .50        | ± 2.50    | ± 1.00        |
| M-33    | 7.50   | $\frac{5}{16}-\frac{1}{2}$ | 33                         | .50        | ± 3.00    | ± 1.00        |
| M-6A-2A | 8.00   | 0- $\frac{1}{2}$           | 2                          | .55        | ± 3.25    | ± 1.25        |
| M-6A-33 | 8.00   | 0- $\frac{1}{2}$           | 33                         | .55        | ± 3.25    | ± 1.25        |
| M-6A-E  | ± 8.00 | 0- $\frac{1}{2}$           | E                          | .55        | ± 3.25    | ± 1.25        |

### LIGHT DUTY—FOR THREADED SPINDLES

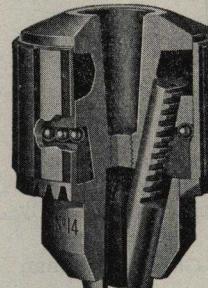
|            |                | Taper                      |           | Jaws and   |               |                |
|------------|----------------|----------------------------|-----------|------------|---------------|----------------|
| Model Nos. | Complete, Each | Cap., In.                  | Hole Nos. | Keys, Each | Sleeves, Each | Balls, Per Set |
| M-8½N      | \$6.50         | 0- $\frac{1}{4}$           | 2 Short   | \$0.45     | ± \$2.50      | ± \$1.00       |
| M-11N      | 8.50           | 0- $\frac{3}{8}$           | 2         | .50        | ± 3.50        | ± 1.25         |
| M-14N      | 11.00          | 0- $\frac{1}{2}$           | 3         | .55        | ± 4.50        | ± 1.75         |
| M-16N      | 13.50          | $\frac{3}{16}-\frac{5}{8}$ | 3         | .80        | ± 5.50        | ± 2.00         |
| M-18N      | 17.50          | $\frac{3}{16}-\frac{3}{4}$ | 4         | .80        | ± 7.00        | ± 2.75         |
| M-20N      | 24.00          | $\frac{3}{8}-1$            | 5         | 1.35       | ± 9.50        | ± 3.75         |

Universal combination of strength and hardness in nickel molybdenum steel jaws—heat treated in new atmospherically controlled furnace.

Diamond bored taper hole in hardened and ground body increases accuracy—assures perfect fit on machine spindle.

## Ball Bearing Super Chucks

Ball bearings eliminate friction. Coarse pitch threads assure quick action and strength. Ground parts promise maximum accuracy.



For use in machine shop and tool room on drilling machines, lathes, woodworking machines. Easily tightened by hand for ordinary drilling and tool work.

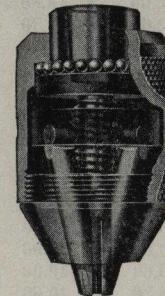
Easy-grip internally and externally ground sleeve, and new nickel molybdenum alloy steel jaws that will stand continuous service on the most difficult production assignments. The body, including the taper hole, is hardened and ground. Ball bearings eliminate friction. Coarse pitch threads on the jaws and nut provide tremendous strength and gripping power.

| Model Nos. | Complete, Each | Taper                      |           | Jaws and   |               | Balls, Per Set |
|------------|----------------|----------------------------|-----------|------------|---------------|----------------|
|            |                | Cap., In.                  | Hole Nos. | Keys, Each | Nuts, Per Set |                |
| M-8½N      | \$6.50         | 0- $\frac{1}{4}$           | 2 Short   | \$0.45     | ± \$2.50      | ± \$1.00       |
| M-11N      | 8.50           | 0- $\frac{3}{8}$           | 2         | .50        | ± 3.50        | ± .45          |
| M-14N      | 11.00          | 0- $\frac{1}{2}$           | 3         | .55        | ± 4.50        | ± .60          |
| M-16N      | 13.50          | $\frac{3}{16}-\frac{5}{8}$ | 3         | .80        | ± 5.50        | ± .75          |
| M-18N      | 17.50          | $\frac{3}{16}-\frac{3}{4}$ | 4         | .80        | ± 7.00        | ± .75          |
| M-20N      | 24.00          | $\frac{3}{8}-1$            | 5         | 1.35       | ± 9.50        | ± .90          |

Note: The new N model Super Chucks have an inserted ball thrust race. Except for key, parts are not interchangeable with the old style Super Chucks and orders for "N" model repair parts should so specify.

## Keyless Portomatic Chucks

Self tightening—unequalled for gripping power



Designed for use on portable drills where keyless or hand operated feature is desirable.

Ball bearing, rapid in action, powerful, yet easily released by a slight twist of the knurled sleeve. A tremendous grip which automatically tightens with increased load. Hardened and ground throughout. Perfect fit on all running parts.

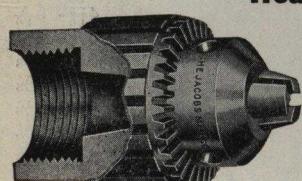
| Model Nos.     | Complete, Each | Cap., In.                 | Taper                      | Jaws, Car- |                 | Col- lars, Each | Balls, Per Set |
|----------------|----------------|---------------------------|----------------------------|------------|-----------------|-----------------|----------------|
|                |                |                           |                            | Hole In.   | Screws, Per Set | Carriers, Each  |                |
| M-250          | \$8.00         | 0- $\frac{1}{4}$          | 2 Short                    | ± \$2.00   | ± \$1.75        | ± \$1.75        | ± \$0.75       |
| M-250-1A       | ± 8.00         | 0- $\frac{1}{4}$          | 1                          | ± 2.00     | ± 1.75          | ± 1.75          | ± .75          |
| M-312          | 9.00           | 0- $\frac{5}{16}$         | 2 Short                    | ± 2.25     | ± 2.00          | ± 2.00          | ± .90          |
| M-375          | 10.00          | 0- $\frac{3}{8}$          | 2                          | ± 2.50     | ± 2.25          | ± 2.25          | ± 1.00         |
| M-500          | 12.00          | $\frac{1}{6}-\frac{1}{2}$ | 6                          | ± 3.00     | ± 2.50          | ± 2.50          | ± 1.25         |
| Thread, Inches |                |                           |                            |            |                 |                 |                |
| M-250B         | \$8.00         | 0- $\frac{1}{4}$          | { $\frac{5}{16} \times 24$ | ± 2.00     | ± 1.75          | ± 1.75          | ± .40          |
| M-312B         | 9.00           | 0- $\frac{5}{16}$         | { $\frac{5}{16} \times 24$ | ± 2.25     | ± 2.00          | ± 2.00          | ± .50          |
| M-375B         | 10.00          | 0- $\frac{3}{8}$          | { $\frac{1}{2} \times 20$  | ± 2.50     | ± 2.25          | ± 2.25          | ± .60          |
| M-500B         | 12.00          | $\frac{1}{6}-\frac{1}{2}$ | { $\frac{5}{16} \times 16$ | ± 3.00     | ± 2.50          | ± 2.50          | ± .60          |

### MEDIUM DUTY—FOR THREADED SPINDLES

| Nos.  | Each    | Cap., In.                  | Size Hole, In.  |         | Sleeves, Each |
|-------|---------|----------------------------|---|---------|---------------|
|       |         |                            | Spindles  | Threads |               |
| M-7B  | \$5.50  | 0- $\frac{1}{4}$           | %x24 or $\frac{1}{2} \times 20$   |         |               |
| M-30B | 6.00    | 0- $\frac{1}{6}$           | %x24 or $\frac{1}{2} \times 20$   |         |               |
| M-32B | 6.50    | 0- $\frac{3}{8}$           | $\frac{1}{2} \times 20$ , $\frac{5}{16} \times 16$ or $\frac{1}{4} \times 16$ |         |               |
| M-34B | 8.00    | 0- $\frac{1}{2}$           | $\frac{5}{16} \times 16$ , $\frac{1}{4} \times 16$ or $\frac{3}{8} \times 16$ |         |               |
| M-3B  | 9.50    | $\frac{1}{8}-\frac{5}{8}$  | $\frac{5}{16} \times 16$ , $\frac{1}{4} \times 16$ or $\frac{3}{8} \times 16$ |         |               |
| M-36B | ± 12.00 | $\frac{3}{16}-\frac{3}{4}$ | $\frac{5}{16} \times 16$ or $\frac{3}{8} \times 16$                           |         |               |

Parts for B threaded chucks are interchangeable with the tapered models and carry the same list prices.

## Headstock Chucks



Extremely accurate—easy to use. Made to thread directly to the spindles of several small lathes.

Hollow construction enables chucking long pieces extending into spindle of lathe. This chuck is ideal equipment for valve refacing on the lathe when combined with tool post grinder.

| Nos.  | Each    | Cap., In.                  | Threaded, In.      |
|-------|---------|----------------------------|--------------------|
| M-55B | ± 13.25 | *0- $\frac{17}{32}$        | 1x8                |
| M-56B | ± 13.25 | *0- $\frac{17}{32}$        | 1x10               |
| M-58B | ± 16.50 | $\frac{1}{8}-\frac{5}{8}$  | 1 $\frac{1}{2}$ x8 |
| M-59B | ± 19.75 | $\frac{3}{16}-\frac{3}{4}$ | 1 $\frac{1}{2}$ x8 |

\*  $\frac{1}{8}-\frac{5}{8}$  optional.

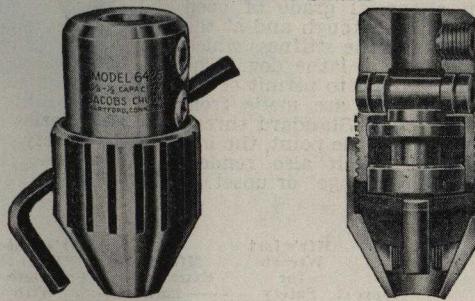
Retail prices quoted above are those found to be prevailing in the Cleveland area. Freight to destination should be added.

± Goods marked thus (±) are not carried in stock and can be furnished only by shipment direct from factory.

**Jacobs Rubber-Flex Chucks**  
 For Home Workshop and on Popular Priced Power Tools  
 What the Rubber-Flex Jaw Assembly IS and DOES

Entirely new — the Rubber-Flex Jaw Assembly is a single unit of one-piece construction — no loose jaws or springs. The hardened alloy steel jaws are permanently bonded together by a synthetic rubber compound. The collet jaws are parallel to the tool shank at all times assuring tremendous gripping power. Designed to provide accuracy never before obtained in popular priced chucks, each collet has a very wide capacity.

**HEX-KEY MODELS**  
 Straight Hole Models for Drill Presses,  
 Lathes and Motor Shafts



Inside View

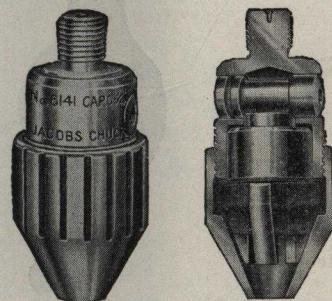
The new Jacobs Hex-Key Chuck has become noted of its accuracy, range and great gripping power. Developed especially for home workshop power tools, these chucks fit directly onto  $\frac{1}{2}$ -inch or  $\frac{5}{8}$ -inch drill press spindles, motorshafts, and jackshafts. By means of a Morse Taper Arbor, they can be used on the lathe headstock or tailstock, drill press or any other spindle with a Morse Taper socket.

The famous Rubber-Flex Jaw Assembly is of one-piece construction—no loose jaws or springs. A simple cam actuated locking device provides a rigid grip on the drill or tool shank.

Hardened and ground collet jaws assure standards of accuracy never before obtained in a chuck designed for the home craftsman or artisan.

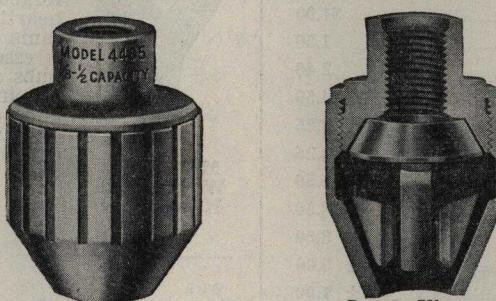
| Nos.   | Cap.                          |        | Length         |                | Hole           |               | Nos.   | Cap.                          |        | Dia.           |                | Lgth.         | Thread            | Hole           |
|--------|-------------------------------|--------|----------------|----------------|----------------|---------------|--------|-------------------------------|--------|----------------|----------------|---------------|-------------------|----------------|
|        | Ins.                          | Each   | Ins.           | Ins.           | Ins.           | Ins.          |        | Ins.                          | Each   | Ins.           | Ins.           | Ins.          | Ins.              | Size           |
| M-6325 | 0- $\frac{3}{8}$              | \$4.00 | $1\frac{3}{8}$ | $3\frac{1}{2}$ | $3\frac{1}{8}$ | $\frac{1}{2}$ | M-4164 | 0- $\frac{1}{4}$              | \$1.30 | $1\frac{1}{8}$ | $1\frac{1}{2}$ | $\frac{1}{2}$ | $\frac{1}{2}$ -20 | $1\frac{1}{8}$ |
| M-6326 | 0- $\frac{3}{8}$              | 4.00   | $1\frac{3}{8}$ | $3\frac{1}{2}$ | $3\frac{1}{8}$ | $\frac{5}{8}$ | M-4165 | 0- $\frac{1}{4}$              | 1.30   | $1\frac{1}{8}$ | $1\frac{1}{2}$ | $\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |
| M-6425 | $\frac{1}{8}$ - $\frac{1}{2}$ | 4.00   | $1\frac{3}{8}$ | $3\frac{1}{2}$ | $3\frac{1}{8}$ | $\frac{1}{2}$ | M-4191 | 0- $\frac{1}{4}$              | 1.30   | $1\frac{1}{8}$ | $1\frac{1}{2}$ | $\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |
| M-6426 | $\frac{1}{8}$ - $\frac{1}{2}$ | 4.00   | $1\frac{3}{8}$ | $3\frac{1}{2}$ | $3\frac{1}{8}$ | $\frac{5}{8}$ | M-4364 | 0- $\frac{3}{8}$              | 2.00   | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ | $\frac{1}{2}$ -20 | $1\frac{1}{8}$ |
|        |                               |        |                |                |                |               | M-4365 | 0- $\frac{3}{8}$              | 2.00   | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |
|        |                               |        |                |                |                |               | M-4464 | $\frac{1}{8}$ - $\frac{1}{2}$ | 2.00   | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ | $\frac{1}{2}$ -20 | $1\frac{1}{8}$ |
|        |                               |        |                |                |                |               | M-4465 | $\frac{1}{8}$ - $\frac{1}{2}$ | 2.00   | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |

Collets on  $\frac{1}{2}$  and  $\frac{5}{8}$ -inch chucks are interchangeable.

Inside View  
Capacity  
Ins.  
Each

| Nos.   | Capacity<br>Ins.              | Each   |
|--------|-------------------------------|--------|
| M-6141 | 0- $\frac{1}{4}$              | \$3.00 |
| M-6444 | $\frac{1}{8}$ - $\frac{1}{2}$ | 4.00   |

**HAND-TITE MODELS**  
 Threaded Models for Hand and Breast Drills,  
 Flexible Shafts and Polishing Heads



Inside View

The Hand-Tite Chuck is especially designed for hand and power driven tools having threaded spindles. The heart of this chuck is also the Rubber-Flex Jaw Assembly with its one-piece construction—no loose jaws or springs. This chuck offers the home craftsman or artisan unusual accuracy, great gripping power and is built for long life. This chuck is especially intended for use on hand and breast drills, on flexible shaft equipment and threaded spindle polishing heads and grinders.

Each chuck not only has a wide range capacity, but has also been engineered for unusual accuracy and a rigid grip. It will not permit the tool to slip.

| Nos.   | Cap.                          | Ins.   | Each | Dia.           | Lgth.          | Thread            | Hole           |
|--------|-------------------------------|--------|------|----------------|----------------|-------------------|----------------|
| Nos.   | Cap.                          | Ins.   | Each | Dia.           | Ins.           | Ins.              | Size           |
| M-4164 | 0- $\frac{1}{4}$              | \$1.30 |      | $1\frac{1}{8}$ | $1\frac{1}{2}$ | $\frac{1}{2}$ -20 | $1\frac{1}{8}$ |
| M-4165 | 0- $\frac{1}{4}$              | 1.30   |      | $1\frac{1}{8}$ | $1\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |
| M-4191 | 0- $\frac{1}{4}$              | 1.30   |      | $1\frac{1}{8}$ | $1\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |
| M-4364 | 0- $\frac{3}{8}$              | 2.00   |      | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ -20 | $1\frac{1}{8}$ |
| M-4365 | 0- $\frac{3}{8}$              | 2.00   |      | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |
| M-4464 | $\frac{1}{8}$ - $\frac{1}{2}$ | 2.00   |      | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ -20 | $1\frac{1}{8}$ |
| M-4465 | $\frac{1}{8}$ - $\frac{1}{2}$ | 2.00   |      | $1\frac{1}{8}$ | $2\frac{1}{2}$ | $\frac{1}{2}$ -24 | $1\frac{1}{8}$ |

**HEX-KEY MODELS****Threaded Models For Portable Drills**

These models are similar to the straight hole type except in the method of attaching. To reduce the distance between the chuck and the drill spindle bearing, these models are provided with a threaded body which screws into a threaded hole in the spindle. The same hex key and cam arrangement for positive tightening of the chuck is used. Two models, affording a capacity range up to  $\frac{1}{2}$  inch, are available.

| Diameter       | Open<br>Ins.   | Closed<br>Ins.  | Thread<br>Dimensions | Length |
|----------------|----------------|-----------------|----------------------|--------|
| $1\frac{1}{8}$ | $2\frac{1}{8}$ | $1\frac{1}{4}$  | $\frac{3}{8}$ x24    |        |
| $1\frac{1}{8}$ | $3\frac{1}{2}$ | $2\frac{9}{16}$ | $\frac{1}{2}$ x20    |        |

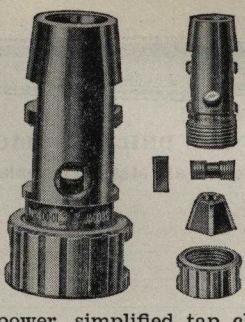
**Jacobs Rubber-Flex Chuck Display Assortments**

Assortment consists of two (2) Hex-Key Chucks, seven (7) Hand-Tite Chucks; two (2) Morse Taper Arbors and one (1) collet put up in a counter display box. For complete description of contents see listing below.

| Quantity | Item                           | Capacity, Ins.                |
|----------|--------------------------------|-------------------------------|
| 2        | M-6425 Hex Key Chucks          | $\frac{1}{8}$ - $\frac{1}{2}$ |
| 1        | M-6425 No. 1 Morse Taper Arbor |                               |
| 1        | M-6425 No. 2 Morse Taper Arbor |                               |
| 1        | M-J63 Collet for M-6426 Chuck  | 0- $\frac{3}{8}$              |
| 4        | M-4165 Hand-Tite Chucks        | 0- $\frac{1}{4}$              |
| 1        | M-4191 Hand-Tite Chuck         | 0- $\frac{1}{4}$              |
| 2        | M-4465 Hand-Tite Chucks        | $\frac{1}{8}$ - $\frac{1}{2}$ |

**M-2160 Assortments** Each \$21.60

One in a carton.

**Jacobs Rubber-Flex Tap Chucks**

For the tapping head, tapping machine, drill press, automatic or hand screw machine—can be attached either directly to the spindle or by means of a straight or tapered shank arbor.

Light weight, small diameter, precision ground construction, tremendous gripping power, simplified tap changing—all combine to make this holder an ideal tap chuck.

**Light Weight**—Combined with small diameter keep to a minimum that inertia which a holder builds up on a tapping spindle.

**Positive Drive**—Floating back jaws provide positive drive on all sizes of tap squares.

**Gripping Power**—The parallel bite of the Rubber-Flex collet prevents disengagement of the positive drive.

**Accuracy**—Completely ground collet and chuck body mean unusual control of run-out.

**Simplified Tap Changing**—Quarter turn of cap and the jaw screw disengages tap from chuck.

**Wide Collet Range**—One collet takes all taps in its range—no individual sleeves or changing required.

The list price of the chuck includes the body wrench, nut wrench and hex key.

| Nos.       | Collet No. | Taper Hole No. | Nut Wrench Flat, Ins. | Body Wrench Flat, Ins. | Hex Key Size Ins. |
|------------|------------|----------------|-----------------------|------------------------|-------------------|
| M-400-01   | J-400      | 1              | $\frac{3}{4}$         | $\frac{1}{2}$          | $\frac{3}{8}$     |
| ‡ M-420-01 | J-420      | 1              | $\frac{31}{32}$       | $\frac{11}{16}$        | $\frac{1}{8}$     |
| M-420-02   | J-420      | 2 Short        | $\frac{31}{32}$       | $\frac{11}{16}$        | $\frac{1}{8}$     |
| M-421-01   | J-421      | 1              | $\frac{31}{32}$       | $\frac{11}{16}$        | $\frac{1}{8}$     |
| ‡ M-421-02 | J-421      | 2 Short        | $\frac{31}{32}$       | $\frac{11}{16}$        | $\frac{1}{8}$     |
| M-440-02   | J-440      | 2              | $1\frac{5}{16}$       | $\frac{31}{32}$        | $\frac{5}{32}$    |
| ‡ M-440-06 | J-440      | 6              | $1\frac{5}{16}$       | $\frac{31}{32}$        | $\frac{5}{32}$    |
| M-441-02   | J-441      | 2              | $1\frac{5}{16}$       | $\frac{31}{32}$        | $\frac{5}{32}$    |
| ‡ M-441-06 | J-441      | 6              | $1\frac{5}{16}$       | $\frac{31}{32}$        | $\frac{5}{32}$    |

| Nos.       | Mfr's List, Each | Capacity No. or Ins.           |
|------------|------------------|--------------------------------|
| M-400-01   | \$ 9.50          | 0 - 10                         |
| ‡ M-420-01 | 10.50            | 10 - $\frac{5}{16}$            |
| M-420-02   | 10.50            | 10 - $\frac{5}{16}$            |
| M-421-01   | 10.50            | 0 - $\frac{1}{4}$              |
| ‡ M-421-02 | 10.50            | 0 - $\frac{1}{4}$              |
| M-440-02   | 12.00            | $\frac{5}{16}$ - $\frac{1}{2}$ |
| ‡ M-440-06 | 12.00            | $\frac{5}{16}$ - $\frac{1}{2}$ |
| M-441-02   | 12.00            | 10 - $\frac{1}{2}$             |
| ‡ M-441-06 | 12.00            | 10 - $\frac{1}{2}$             |

The J-420 collet is interchangeable with the J-421. Thus, a J-421 collet mounted in M-420-01 chuck changes its range to hold 0- $\frac{1}{4}$  taps. The same interchangeability is possible between the J-440 collet and the J-441.

Retail prices quoted above are those found to be prevailing in the Cleveland area. Freight to destination should be added.

‡ Goods marked thus (‡) are not carried in stock and can be furnished only by shipment direct from factory.